

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009081**Date Inspected:** 10-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qi Guo You, Li Lin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, West Tower, Internal Splice Plate(Repair).

FCAW Repair welding of weld joint WD1-SPSA3-56-4B (WRR # T-WR2114); located on Bay11, West Tower. Welder is identified as 040759; ZPMC Quality Control Inspector (QC) is identified as Qi Guo You. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-Repair.

This QA Inspector carried out NDE on following:

Bay 10, North Tower, Lift 3.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA

Inspector generated an MT report (TL-6028) for this date. The members are identified as

1) NSTL3-3B/K-81A. Corner Seam C/D-Internal.

2) NSTL3-3B/K-85A. Corner Seam D/E-Internal.

Bay 10, North Tower, Lift 3.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. The members are identified as

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- 1) WSTL3-4G/K-74, 45, 87 TO 80. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C.
- 2) WSTL3-4F/K-140, 141, 66, 67. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C.
- 3) WSTL3-4C/K-75, 76, 89, 90, 81, 82. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C.
- 4) WSTL3-4B/K-71, 72. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C.
- 5) WSTL3-4G/K-76, 77, 81 to 86. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C Fit Lugs.
- 6) WSTL3-4F/K-138, 139, 142 TO 147, 62 TO 65, 68 TO 71. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C Fit Lugs.
- 7) WSTL3-4C/K-77 TO 80, 83 TO 86. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C Fit Lugs.
- 8) WSTL3-4D/K-72 TO 75, 78, 81. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C Fit Lugs.
- 9) WSTL3-4B/K-67 TO 70, 73 TO 76. 99M Double Diaphragm Lower to 85.25M Diaphragm to Skin C Fit Lugs.

Bay 10, North Tower, Lift 3.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as WSD1-FCSA3-2C/C-3 TO 6. Small Stiffener Between 89M Diaphragm on Skin C.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
